

Order ID 71498



Page 1

Tuesday, July 05, 2011 8:59:45 AM

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

✓ 11 07 22 ①  
OK for BGR 11/07/21

137-1498

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

Handwritten notes and signatures:

- Signature: *JB*
- Date: *11/07/12*
- Signature: *Sh*
- Date: *11/07/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: M115778

BE 11/02/13

12-Grind welds flush as per Dwg D2750

BB 11/07/14

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Subsly

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Subsly

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 *Bu/07/14*

150 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*✓* *0* *QC11/07/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

exp. date:

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

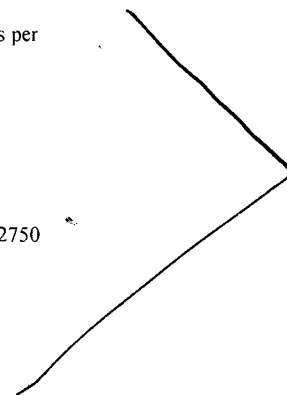
A/R Aluminum Rod

batch:

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per



BB

11/07/14

BB

11/07/14

BB 11/07/18

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

dwg D2750

12-Deburr holes

11/07/18

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Suloxis

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suloxis

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 φ 20 11/07/20

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:30  
OVEN TEMPERATURE: 320°  
FINISH TIME: 8:00

1 φ 16K 11-7-21.

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

✓ Inspect for foreign object per QSI 024

7 φ 9L 11/07/21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	Install inserts as per dwg D2750								
230		0.00							
	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>101A</u>								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>11113516</u> EXP DATE: <u>15101</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>111104189</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>11114596</u>								

1  $\phi$  M 11/07/21

1  $\phi$  M 11/07/21

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Run Start

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**Insp.  
Stamp**

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

0.00

[illegible]

### Packaging

## Packaging

## Memo

0.00

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**Insp.  
Stamp**

270

0.00

**Author's address:** Department of Psychology, University of California, San Diego, La Jolla, CA 92037, USA.  
E-mail: jkagan@ucsd.edu

## Packaging

### Packaging

## Memo

## Packaging

Package as per PPP D350-636-012

060

280

QC21- Final Inspection - Work Order Release

0.00

[illegible]

## Memo

0.00

QC

## Quality Control

11/7/2008

OK 11/07/26

11-07-85 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Work Order ID: 71498



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: L 102.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O  
 10.06.22 revise seq110 DD verf: EC IPP Rev: P 10.10.01 as per  
 IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS4-1032-225		Purchased	No			220	Each	622.0000	38	38			
---------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--



Insert

Location	Loc Qty	Loc Code
ST282	622	
110768	213	
117717	409	

Handwritten: 1107121

Handwritten: x38

AN3C5A		Purchased	No			230	Each	1,381.000	34	34			
--------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Bolt

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1374	
116419	28	
116549	54	
117343	500	
117764	300	
117872	492	

Handwritten: 1107121

Handwritten: x34

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Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

240.0000

4

4



BOLT



11/07/21

11/07/21

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

239

111982

2

116419

23

116549

2

116704

12

117619

50

117688

100

117872

50

xy

AN6C44A

Purchased

No

230

Each

85.0000

4

4



BOLT



11/07/21

11/07/21

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

83

117763

31

117950

50

118112

2

yd

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Shop Packet Print

Page 2

# Picklist Print

Tuesday, July 05, 2011 8:59:41 AM

Page 3

Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

83.0000

1

1



BOLT



1107121

## Location

## Loc Qty

## Loc Code

FP

40

117511

40

x1

FP-A

8

115960

1

116874

7

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38



washer

M118306



(x38) 1107121

AN960C816L

Purchased

No

230

Each

0.0000

1

1



NAS1149C0832R

M114915



(x1) 1107121

WASHER

D2745

Manufactured

No

230

Each

276.0000

8

8



Bushing



1107121

## Location

## Loc Qty

## Loc Code

FP-A

276

68248

41

69529

155

69816

80

x8

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# Picklist Print

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Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

16.0000

1

1



Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

16

B69904

62003

2

x1

65099

3

68109

11

D3492-1

Manufactured No

230

Each

132.0000

8

8



Plug

X D3492-041

Location

Loc Qty

Loc Code

FP

132

69531

8

69819

52

70689

72

x8

D3492-3

Manufactured No

230

Each

124.0000

8

8



Plug

Location

Loc Qty

Loc Code

FP

124

69822

44

70692

80

x8

D3535-25

Manufactured No

230

Each

36.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

36

62233

69284

69743

LAST ONE OF  
batch!!

x1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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12

Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25	Manufactured	No	230	Each	37.0000	1	1
							24 1107121
Gasket							

Location	Loc Qty	Loc Code
FP012	37	
68351	11	
70780	26	

D3537-1	Manufactured	No	230	Each	13.0000	3	3
							24 1107121
Wearpad							

Location	Loc Qty	Loc Code
FP017	13	
69278	6	
69817	7	

D3631-1	Manufactured	No	230	Each	387.0000	8	8
							24 1107121
Washer							

Location	Loc Qty	Loc Code
ST072	387	
68062	387	

D3672-1	Manufactured	No	230	Each	1,122.000	8	8
							24 1107121 PTO = 7
Phenolic Washer							

Location	Loc Qty	Loc Code
ST074	1096	
64177	596	
66821	500	
ST077	26	
52505	26	

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/07/21	230	Replace a Assemble with NAS1515 H3h washers M113362 Permanent change!	MF	11/07/21	X4		

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230 Each

2.0000

1

1



Wearplate

Location

Loc Qty

Loc Code

FP017

2

1369744

62239

2

11

D3793-1

Manufactured No

230 Each

14.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

14

69285

14

11

D3793-3

Manufactured No

230 Each

14.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018

14

68356

6

69283

8

11

D3794-1

Manufactured No

230 Each

36.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP010

36

68355

12

70779

24

11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 7

Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

29.0000

1

1



Gasket



xl 110712

Location

Loc Qty

Loc Code

FP010

17

68357

17

xl

FP018

12

70812

12

MS21043-6

Purchased

No

230

Each

445.0000

4

4



NUT



xl 110712

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

425

112314

415

xl

117887

10

MS21083C8

Purchased

No

230

Each

97.0000

1

1



NUT



xl 110712

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

50

118077

50

ST303

46

115884

0

117423

25

xl

117677

21

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 8

Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

198.0000

8

8



O-RING



u u107121

## Location

## Loc Qty

## Loc Code

FP

96

117460

16

118077

80

FP-A

102

110915

91

115589

11

x8

NAS1611-013

Purchased

No

230

Each

176.0000

8

8



O-RING



u u107121

## Location

## Loc Qty

## Loc Code

FP

171

117291

31

117887

140

FP-A

5

116582

5

x8

AN8C21A

Purchased

No

250

Each

101.0000

2

2



BOLT



2 117121

## Location

## Loc Qty

## Loc Code

ST344

25

117764

25

ST345

76

117562

26

118045

50

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 9

Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD816

Purchased No

250 Each

1.0000

2

2

WASHER 00863A



1/2" washer, Alum

Location

Loc Qty

Loc Code

FP-A

1

106043

1

Manufactured No

250 Each

39.0000

1

D2741



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

39

63589

9

69133

30

Manufactured No

250 Each

83.0000

2

D3493-1



Washer

Location

Loc Qty

Loc Code

ST062

83

68253

23

70697

60

Manufactured No

250 Each

49.0000

2

2

D3532-1



Spacer

Location

Loc Qty

Loc Code

ST065

49

66949

9

69895

40

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 10

Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250 Each

97.0000

2

2



NUT

## Location

## Loc Qty

## Loc Code

FP-B

1

115884

1

ST293

50

118077

50

ST303

46

115884

0

117423

25

117677

21

D2600-3-BENT

Manufactured No

110 Each

18.0000

1

1



Extrusion Bent

## Location

## Loc Qty

## Loc Code

LG

18

66875

8

68137

1

70142

9

D2744

Manufactured No

110 Each

5.0000

1

1



Cap

## Location

## Loc Qty

## Loc Code

LG002

5

62715

1

65086

4

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Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 11

Work Order ID: 71498

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160 Each

5.0000

1

1



350 I Beam



1

*BB 11/07/14*

## Location

## Loc Qty

## Loc Code

LG

5

69886

5

D2743

Manufactured No

160 Each

163.0000

8

8



Crossbolt Spacer



*BE 10/7/15*

## Location

## Loc Qty

## Loc Code

LG

105

69818

105

LG001

58

67766

4

68251

54

D3490-3

Manufactured No

160 Each

77.0000

4

4



Cross Bolt Spacer



*BE 10/7/15*

## Location

## Loc Qty

## Loc Code

LG

77

68952

18

70768

59

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 12

Work Order ID: 71498



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

97.0000

4

4



Cross Bolt Spacer



BE 11/07/15

Location

Loc Qty

Loc Code

LG

95

67773

5

69510

30

69823

60

LG001

2

62450

2

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

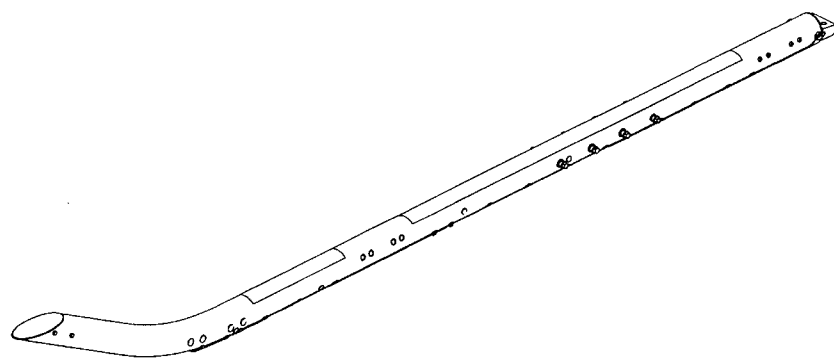
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

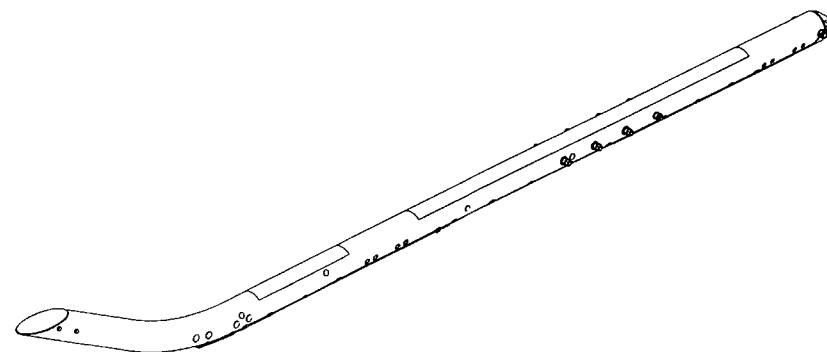
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-5293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RA		
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIES OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2750-041 350 SKIDTUBE ASSEMBLY, LH

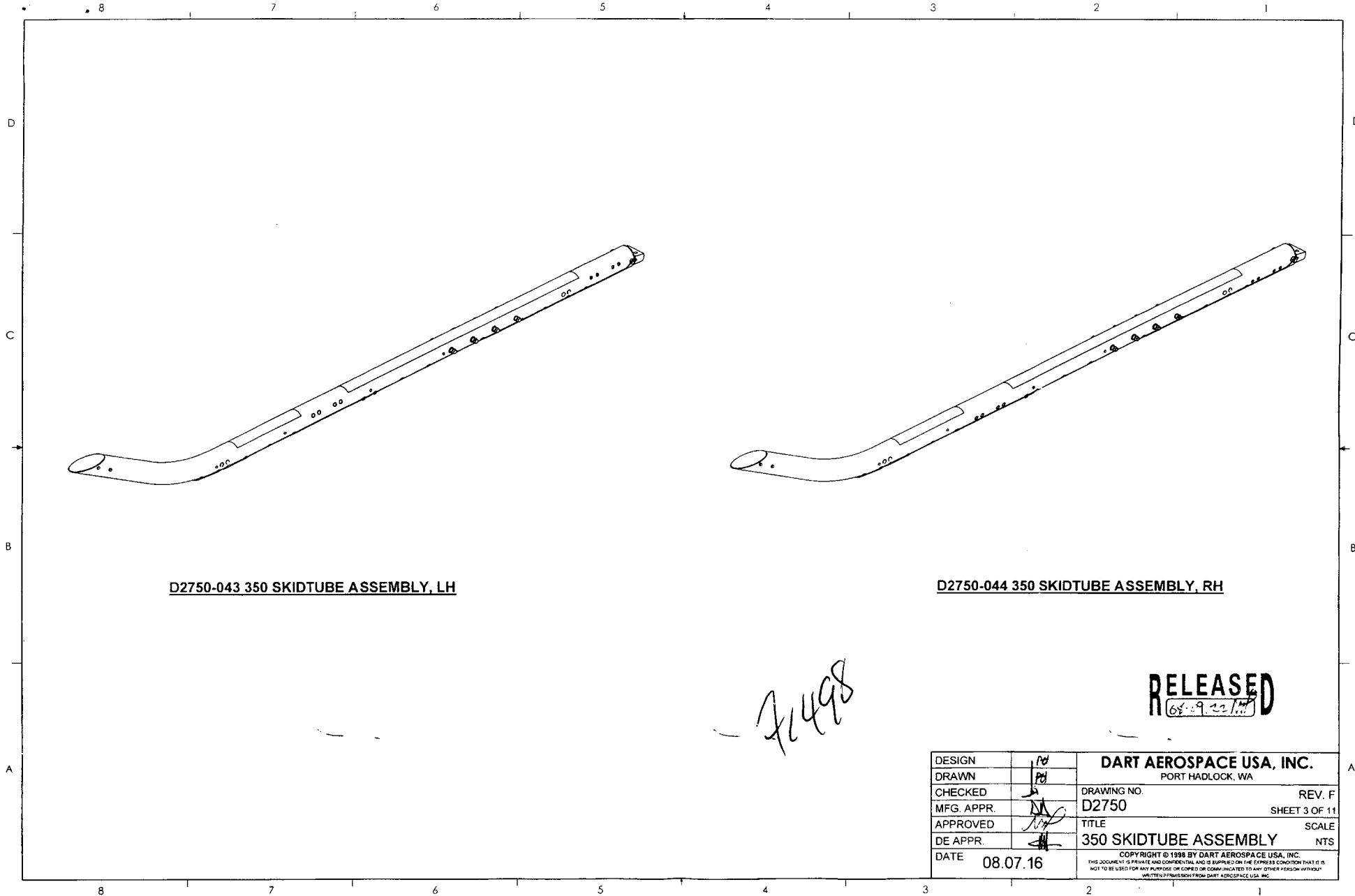


D2750-042 350 SKIDTUBE ASSEMBLY, RH

*2498*

**RELEASED**  
08-09-22 AM

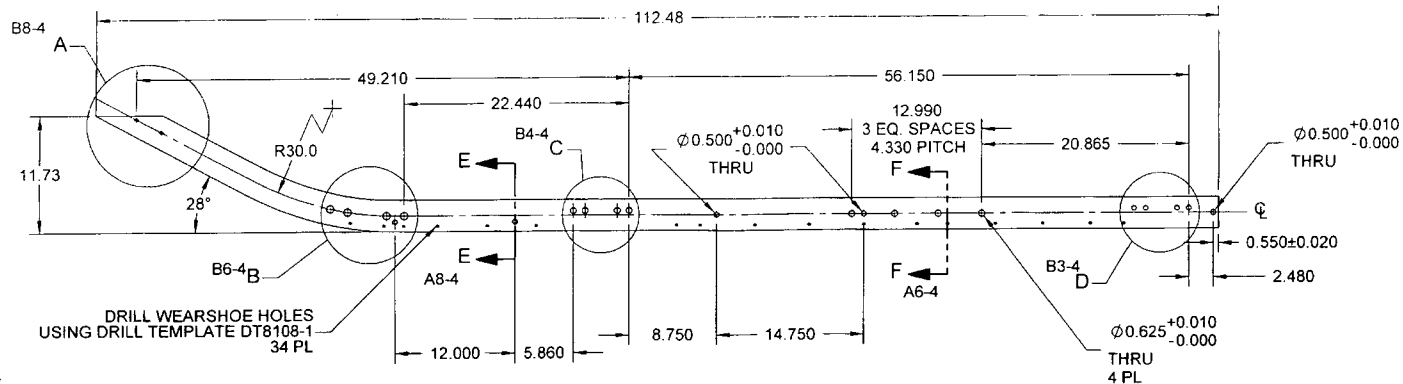
DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	AM	DRAWING NO.	REV. F
MFG. APPR.	AM	<b>D2750</b>	SHEET 2 OF 11
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



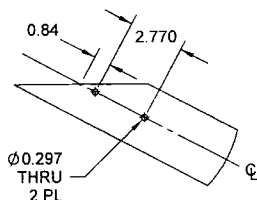
71498

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68-9-22/M

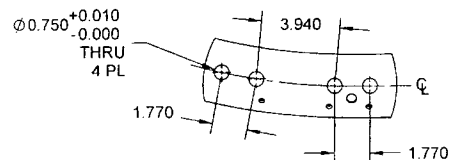
DESIGN	LD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	LD	PORT HADLOCK, WA	
CHECKED	LD	DRAWING NO.	REV. F
MFG. APPR.	LD	D2750	SHEET 3 OF 11
APPROVED	LD	TITLE	SCALE
DE APPR.	LD	350 SKIDTUBE ASSEMBLY	NTS
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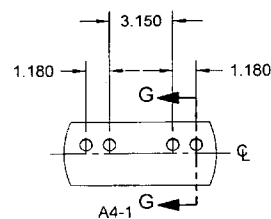
**D2750-1 LH SKIDTUBE**



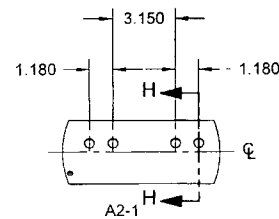
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SCALE 2X



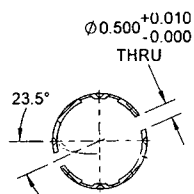
**DETAIL B**  
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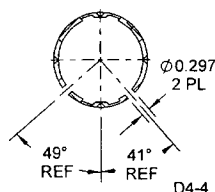
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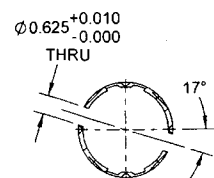
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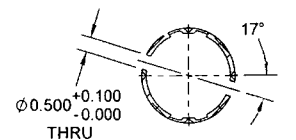
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



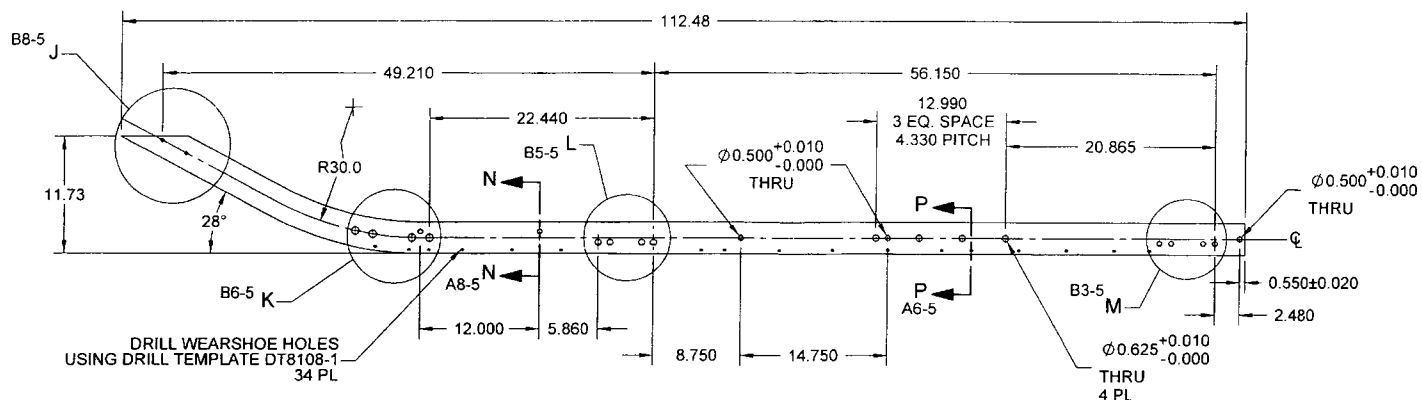
**SECTION G-G**  
SCALE 3X, 4 PL



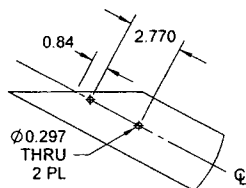
**SECTION H-H**  
SCALE 3X, 4 PL

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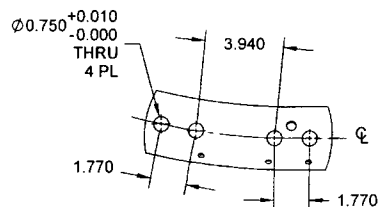
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
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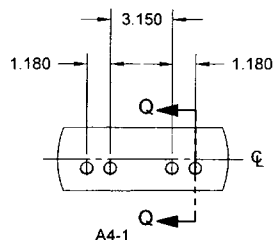
**D2750-2 RH SKIDTUBE**



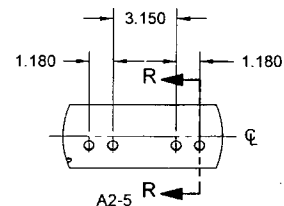
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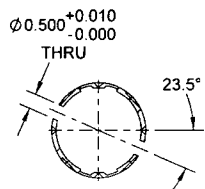
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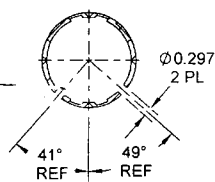
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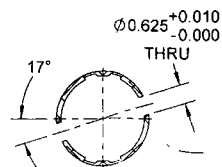
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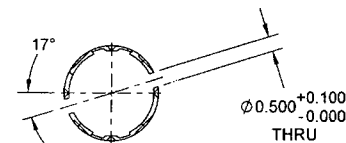
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



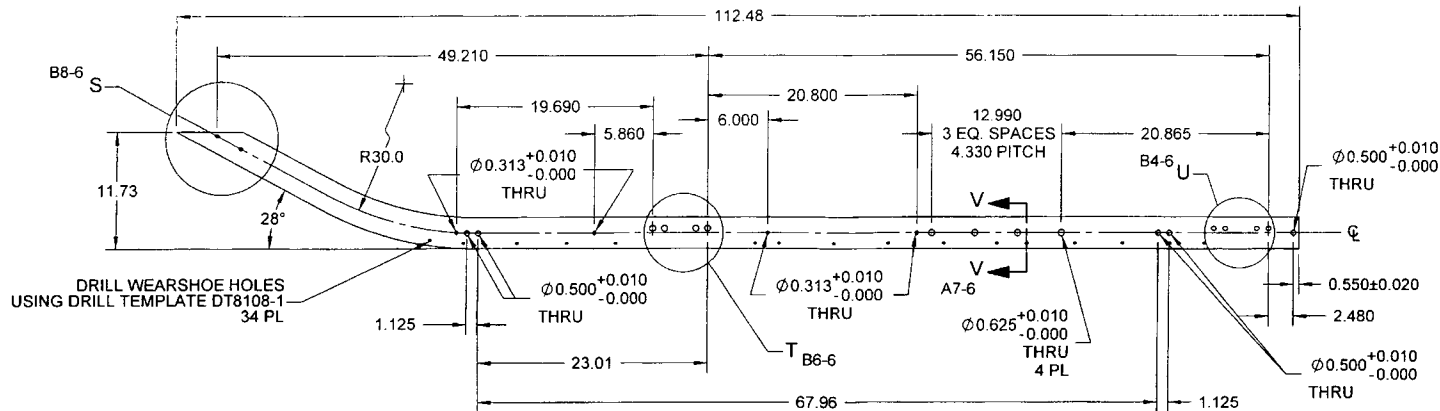
**SECTION Q-Q**  
SCALE 3X, 4 PL



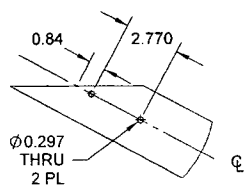
**SECTION R-R**  
SCALE 3X, 4 PL

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08-07-16

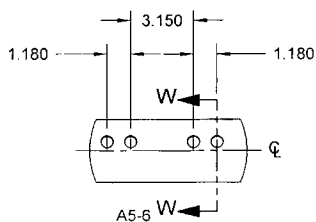
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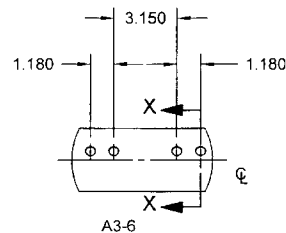
**D2750-3 LH SKIDTUBE**



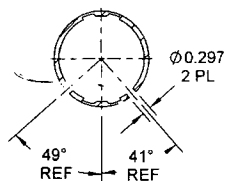
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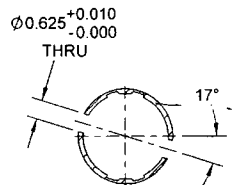
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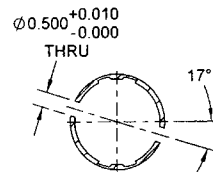
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL

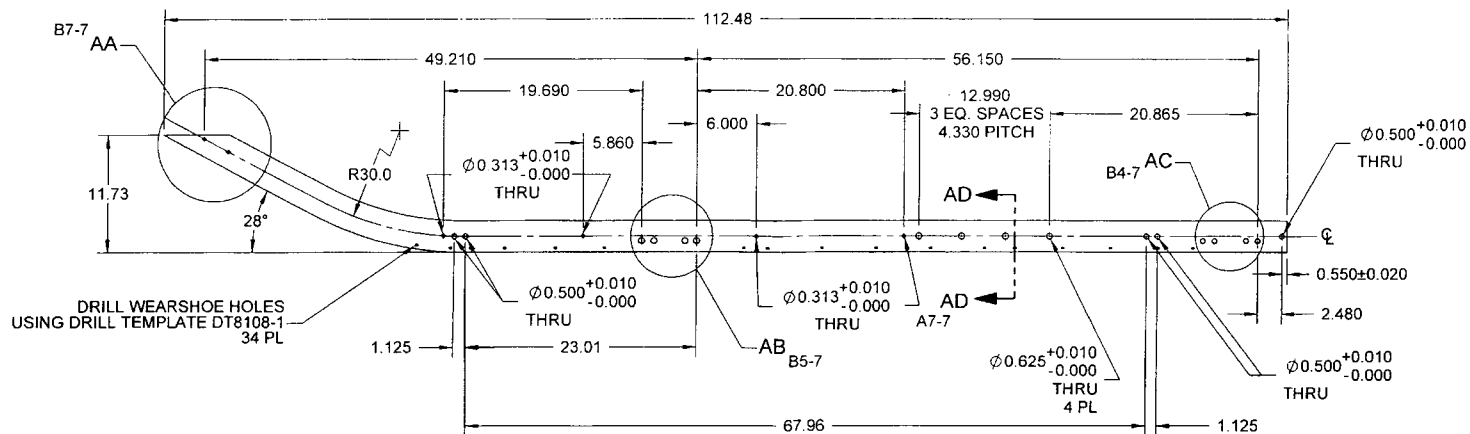


**SECTION X-X**  
SCALE 3X, 4 PL

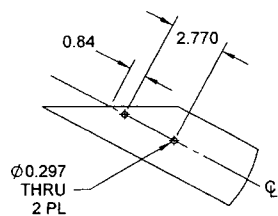
DESIGN		<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		TITLE	SHEET 6 OF 11
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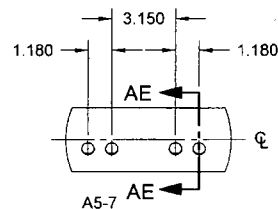
*W107498*



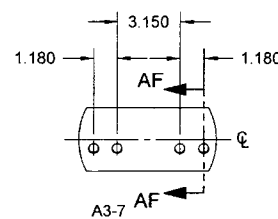
**D2750-4 RH SKIDTUBE**



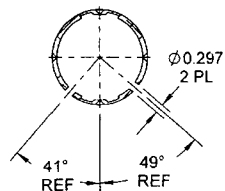
**DETAIL AA**  
SCALE 2X



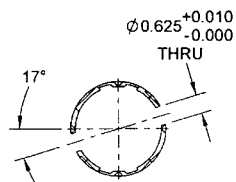
**DETAIL AB**  
SCALE 2X



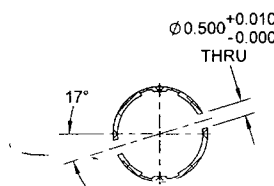
**DETAIL AC**  
SCALE 2X









**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL

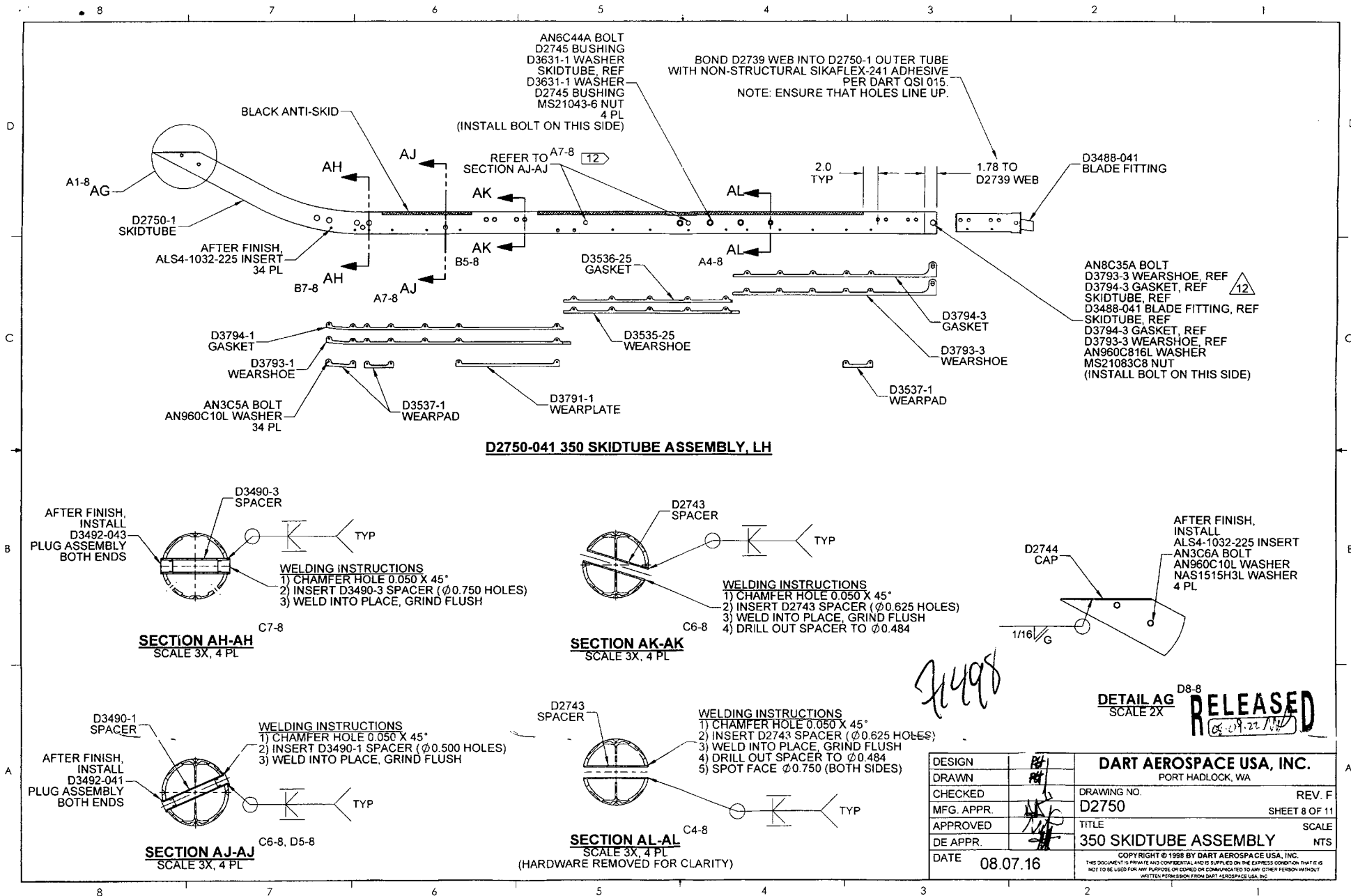


**SECTION AF-AF**  
SCALE 3X, 4 PL

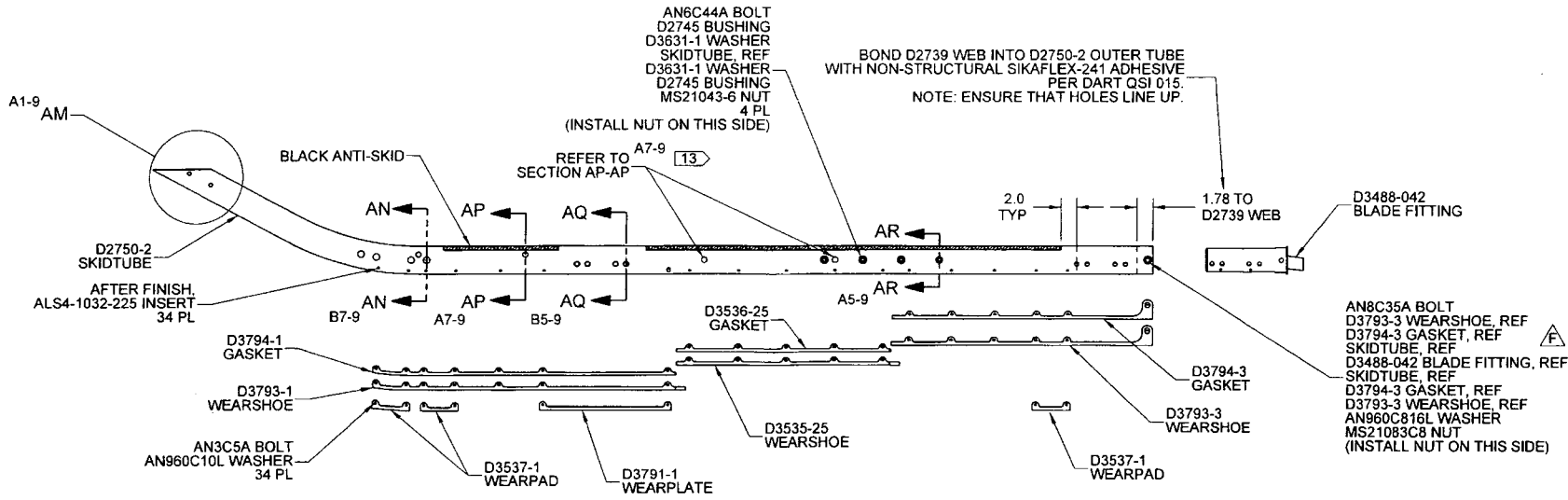
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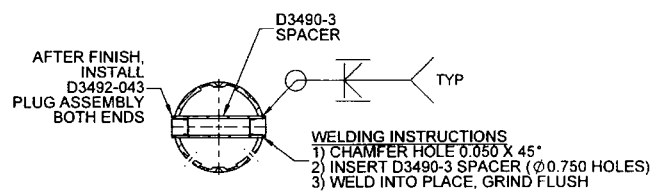




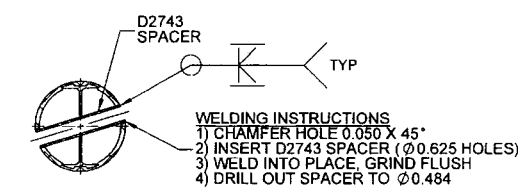
8 7 6 5 4 3 2 1



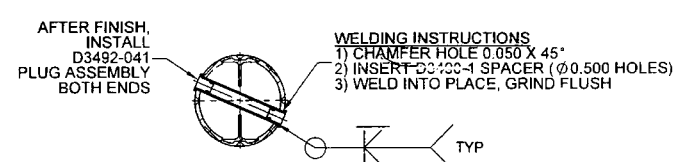
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



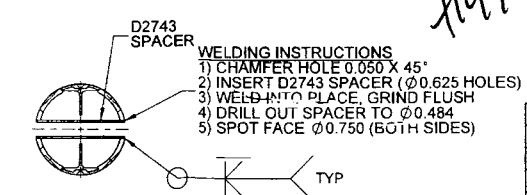
**SECTION AN-AN**  
SCALE 3X, 4 PL



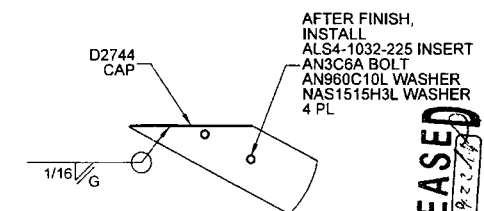
**SECTION AQ-AQ**  
SCALE 3X, 4 PL



**SECTION AP-AP**  
SCALE 3X, 4 PL



**SECTION AR-AR**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

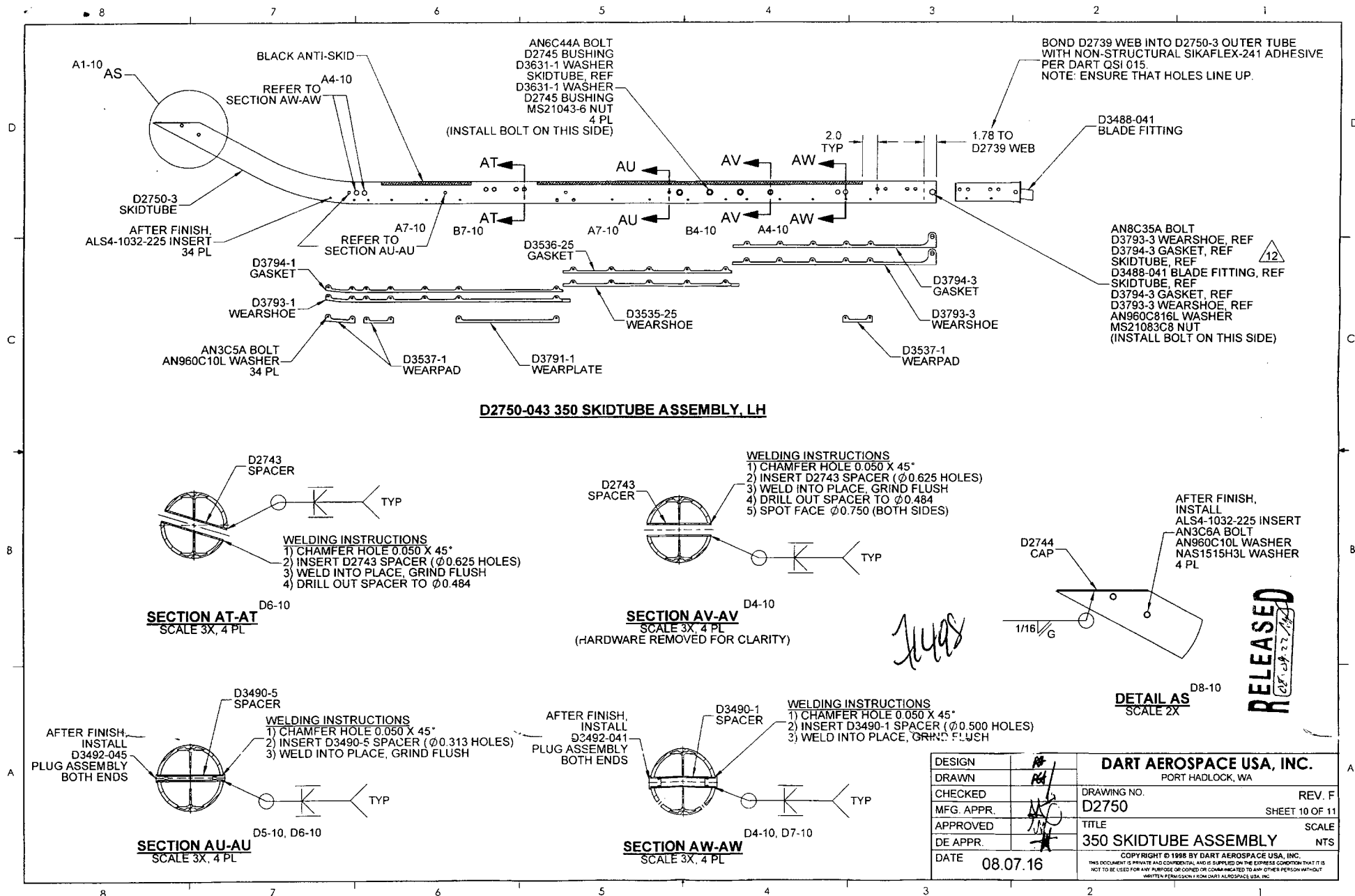


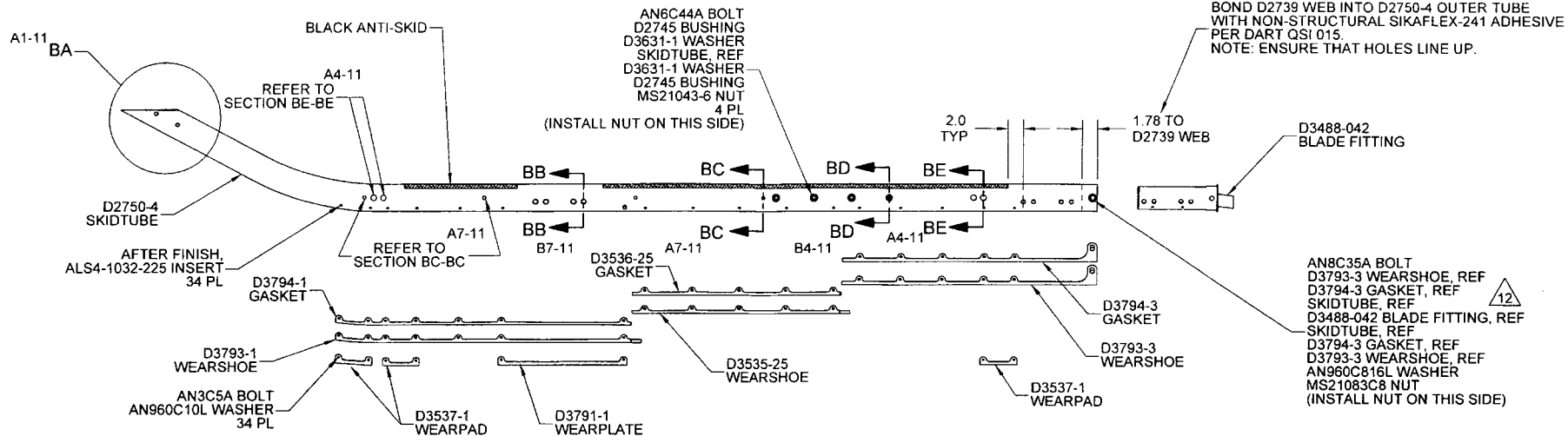
**DETAIL AM**  
SCALE 2X

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
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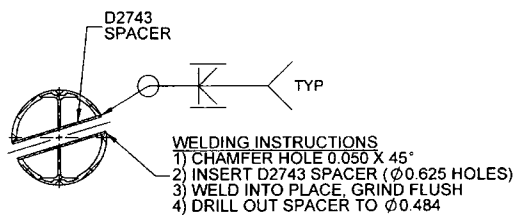
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2008-09-21

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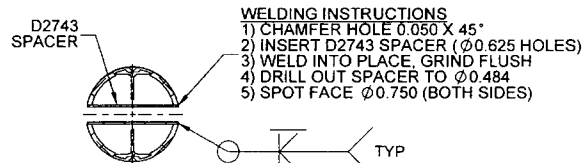




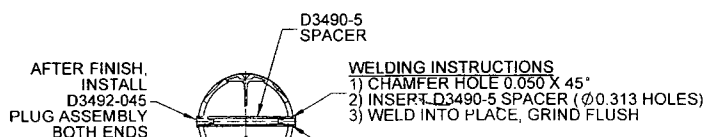
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



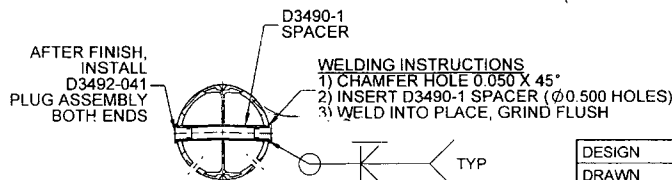
**SECTION BB-BB**  
SCALE 3X, 4 PL



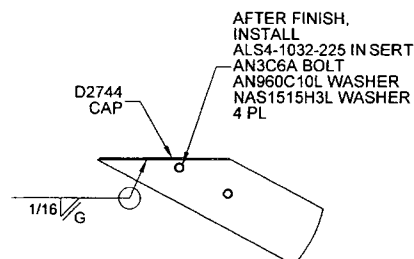
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

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NO. 260

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: B.69407  
Part number: J350 - 636 - 011  
Description: 350  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier: Pat Dunn Date of Test Coupon 11-07-08  
Welder: Barclay Elliott Date of Test Coupon 11-07-08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Eric C.

NCR 11-570

588

480

628

624

Eugene  
Bom